

Date: Monday, 10/16/2006 2:02:28 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HINGE BRACKET  
 Job Number : 29022  
 Estimate Number : 10347  
 P.O. Number : *N/A* Part Number : D28572  
 This Issue : 10/16/2006 S.O. No. : *N/A* Drawing Number : D2857 REV A1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : MACHINED PARTS Drawing Revision : A1  
 Previous Run : 26408 Material : *N/A*  
 Due Date : 10/30/2006 Qty: 24 Um: Each  
 Written By : *[Signature]*  
 Checked & Approved By : *[Signature]*  
 Comment : Est C 00.06.22 Removed P/O for powder coat EC  
 Est D 06.03.30 Added level 8 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X01250 6061-T6 Bar 2.0" x 1.25"



Comment: Qty.: 0.4594 f(s)/Unit Total : 11.0250 f(s)

Material: 2.00" X 1.25"

6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8)

(M6061T6B200001250)

Batch *M16615*

*En 06/11/13 x24*

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks 5.2"

*En 06/11/13 x24*

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per folio D2857-2

*J.G. / En 06/11/14*

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*J.G. 06/11/14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 07/01/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>06/14/02</u>	<u>3D</u>	<u>1 part machined a little barber on the HG Procs</u>						

NOTE: Date & initial all entries

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Drawing Name: HINGE BRACKET

Job Number: 29022

Part Number: D28572

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 06/11/17

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Tumble

2-Deburr any rough edges after tumbling

En 06/11/17 x 24

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.3

SAD 06/11/19

(24)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 06/11/20 (24)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3

Y/S m 102391

06/12/28

(24)

4/12/21

06/12/21

(24)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51391

06/12/29 (24)

10/9/14/02

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/07/02

Job Completion



C 207101102

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29022
<b>Description:</b> Hinge Bracket		<b>Part Number:</b>	D2857-2
<b>Inspection Dwg:</b> D2857 <b>Rev:</b> A1		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.309	✓			
0.340	+/-0.010	0.341	✓			
1.110	+/-0.005	1.109	✓			
1.790	+/-0.010	1.795	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.004	✓			
Ø0.171	+0.005/-0.000	0.174	✓			
0.147	+/-0.010	0.157	✓			
0.376	+/-0.010	0.379	✓			
0.126	+/-0.010	0.116	✓			
0.611	+/-0.010	0.601	✓			
0.063	+/-0.010	0.056	✓			
Ø0.166	+0.005/-0.000	0.167	✓			
0.911	+/-0.010	0.911	✓			
0.600	+/-0.010	0.609	✓			
0.125	+/-0.010	0.125	✓			
0.150	+/-0.010	0.150	✓			

<b>Measured by:</b> S.G	<b>Audited by:</b> SA	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 06/11/14	<b>Date:</b> 06.11.14	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	

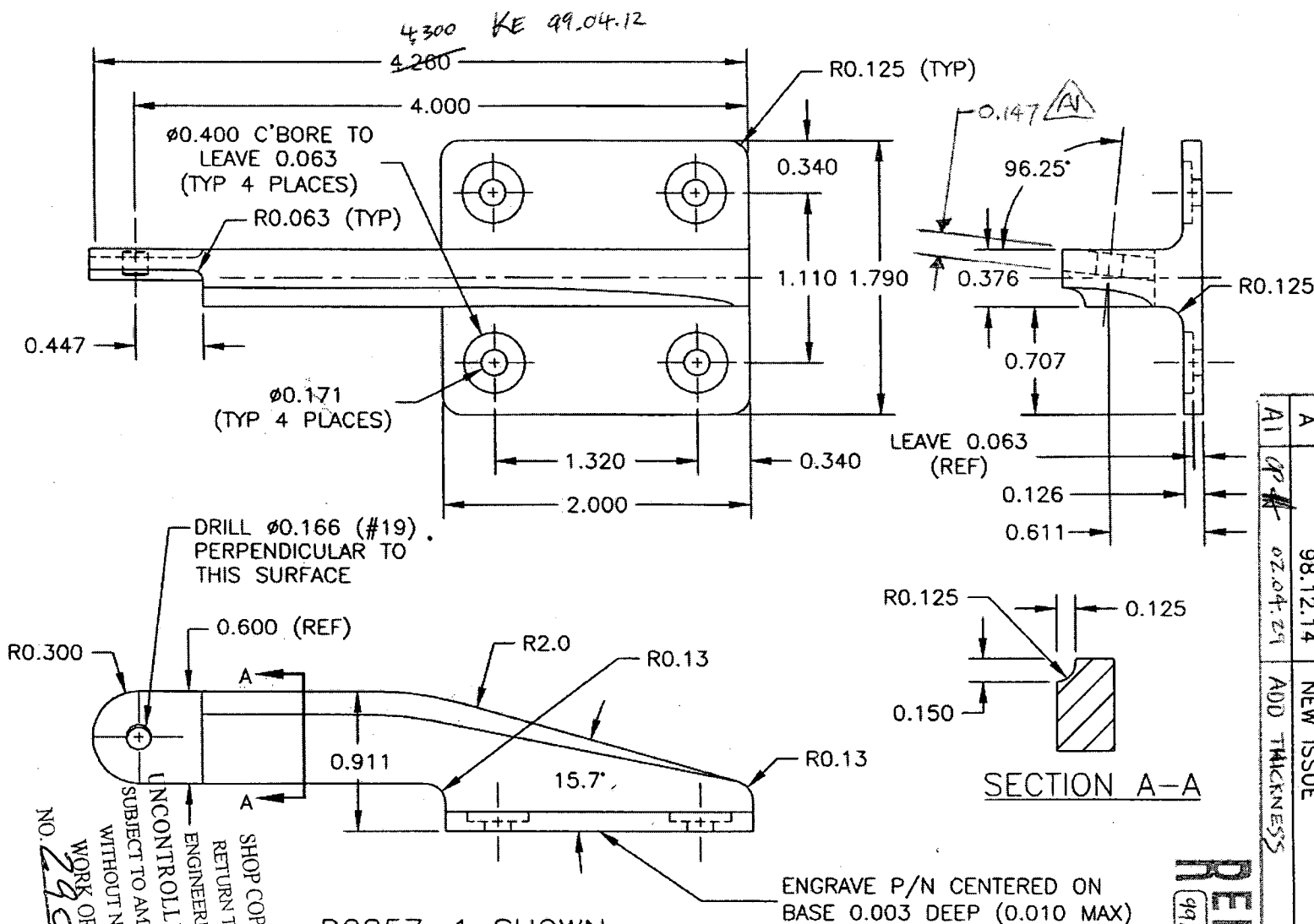
**DART**



DESIGN	DATE	DRAWN BY	DRAWING NO.	REV. A
KE	98.12.14	SP	D2857	1 OF 1
CHECKED		APPROVED		
KE		SP		
DATE		TITLE		SCALE
98.12.14		HINGE BRACKET		1:1
A	98.12.14	NEW ISSUE		
A1	02.04.29	ADD THICKNESS		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

**RELEASED**  
qq, 01, 06 KE



MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED